

Slip Oct. 3

Dart Aerospace Ltd.

S80710/03

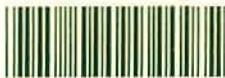
Date: Monday, 10/1/2007 1:37:22 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ARM		
Job Number	: 34919			Part Number	: D2066		
Estimate Number	: 12172			Drawing Number	: D2066 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/1/2007 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 10/8/2007 Qty: 3 Um: Each		
Previous Run	:						
Written By	:						
Checked & Approved By	: <u>TD</u> 07.10.01						
Comment	: Est. 0 02.03.18 Added pick list NG						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M304TR0500W035	304 RD Tube .500 x .035W		
		Comment: Qty.: 2.5043 f(s)/Unit Total : 7.5128 f(s) 304 RD Tube .500 x .035W Punch 1/2" OD x .035" Wall 304/316 SS Seamless Tube (Ref QSI 017 4.1.1.2) as per Dwg D2066 Use punch Jig DT8012 Batch: <u>4105575</u>		SB
2.0	D2052	Bracket		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) Bracket Pick: Qty Part number Description Batch		
		2 D2052 Bracket <u>B17214</u>		SB
3.0	D2055	Clamp		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) Clamp <u>100</u> Pick: Qty Part number Description Batch		
		1 D2055 Clamp <u>B28823</u>		SB
4.0	D2056	Bell Crank Assembly		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Bell Crank Assembly Pick: Qty Part number Description Batch		
		1 D2056 Bellcrank <u>B17049</u>		SB 07/10/03 05

Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Number: 34919

Part Number: D2066

Number:



Seq. #:

Machine Or Operation:

Description:

5.0 D2054

Bushing - Delrin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bushing - Delrin

Pick:

Qty Part number Description

2 D2054 Bushing

Batch
B16711

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Slide on parts per Dwg and W/O for D2676-043

PTO

Punch other end to length (28.62") as per Dwg D2066

Bend per Dwg D2066

Drill 3/16" Dia holes per Dwg D2066

Deburr

MF 07-10-030

7.0 QC5

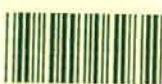
INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

N/A ✓ R

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

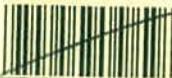


Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 HAND FINISHING1

HAND FINISHING RESOURCE #1

E



Comment: HAND FINISHING RESOURCE #1

Record D2066 Batch number on W/O for D2676-043

Process Sheet

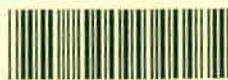
ner: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

umber: 34919

Part Number: D2066

mber:



eq. #:

Machine Or Operation:

Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1/10/3 SCP ①

12.0

QC21

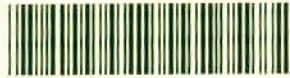
FINAL INSPECTION/W/O RELEASE



07.10.03
JY

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

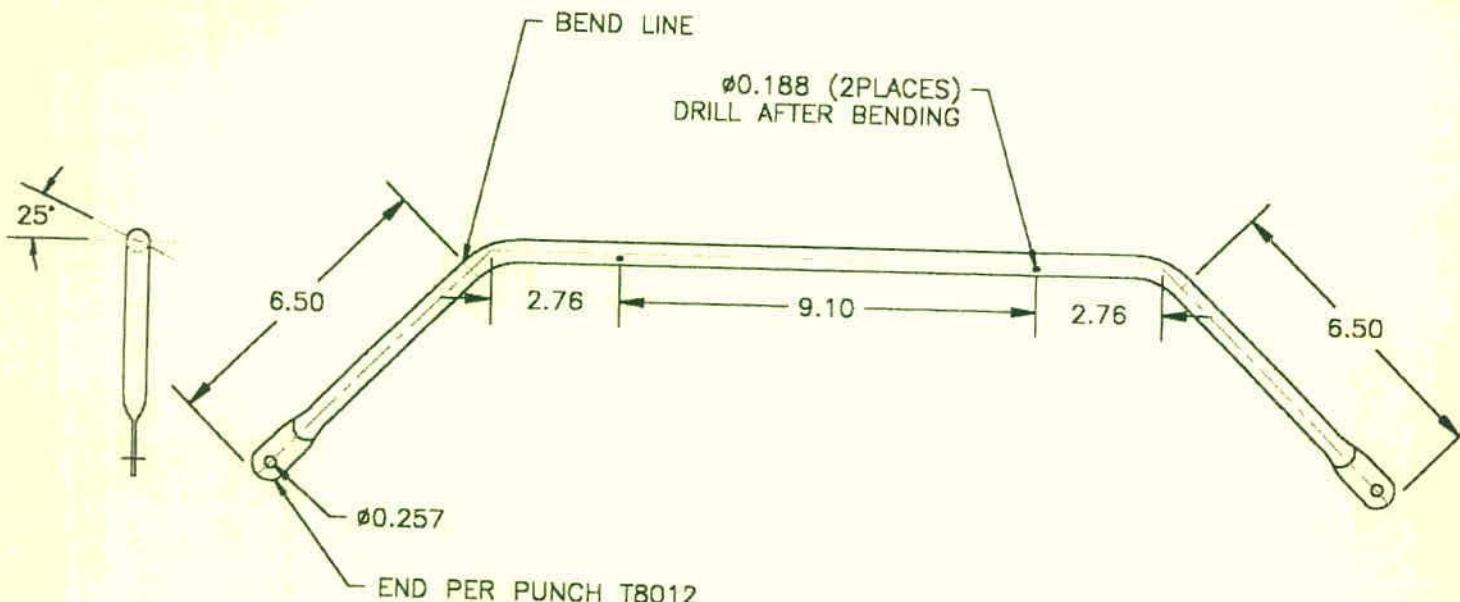


U 87.10.03

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
B. WILLIAMS	B. WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	REV.
<i>B</i>	<i>J</i>	
DATE	DRAWING NO.	SCA
92.03.12	D2066	1
TITLE		
B	ARM	
96.02.06	RE-DESIGNED	



D2066 CUT LENGTH 28.62
NOTE:
ADD D2052, D2055, D2056
D2054 TO ARM BEFORE
ENDS ARE PUNCHED AND
ARM IS BENT

MATERIAL: 304/316 SS 1/2 OD X 0.035 WALL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34914

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/03	6	split up	SB	07/10/03	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

